

Date: Tuesday, 12/5/2006 8:19:18 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 29806	Part Number	: D22303
Estimate Number	: 10256	Drawing Number	: D2230 REV F
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 12/5/2006	Drawing Revision	: F
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 12/23/2006
Previous Run	: 29646	Qty:	196 200 Um: Each
Written By	: <u>[Signature]</u>		
Checked & Approved By	: <u>[Signature] 06 12 05</u>		
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 21.5145 f(s)

Lug Extrusion

D2423

Batch: 323777

2.0	BAND SAW	BAND SAW
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Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch: 323777

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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76

Issue P.O. 2820

cd 07/01/08 196

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

Machine per drawing D2230 Rev F

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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76



Receive & inspect for transit damage



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC2	SECOND CHECK
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Comment: SECOND CHECK

Inspect level 5

05P019

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:19:18 AM
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Drawing Name: MOUNTING LUG

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



185

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

SB

07/02/06

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



185X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MR/gf

07/02/06

8.0

QC53

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

C 07/02/09

185

9.0

POWDER COATING

POWDER COATING



185X

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

MR/gf

07/02/09

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

C 7/2/14

185

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST370

185X

C 7/2/14

185

12.0

QC21

FINAL INSPECTION/W/O RELEASE



185

Comment: FINAL INSPECTION/W/O RELEASE

C 07/02/14

Job Completion



U 07-02-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

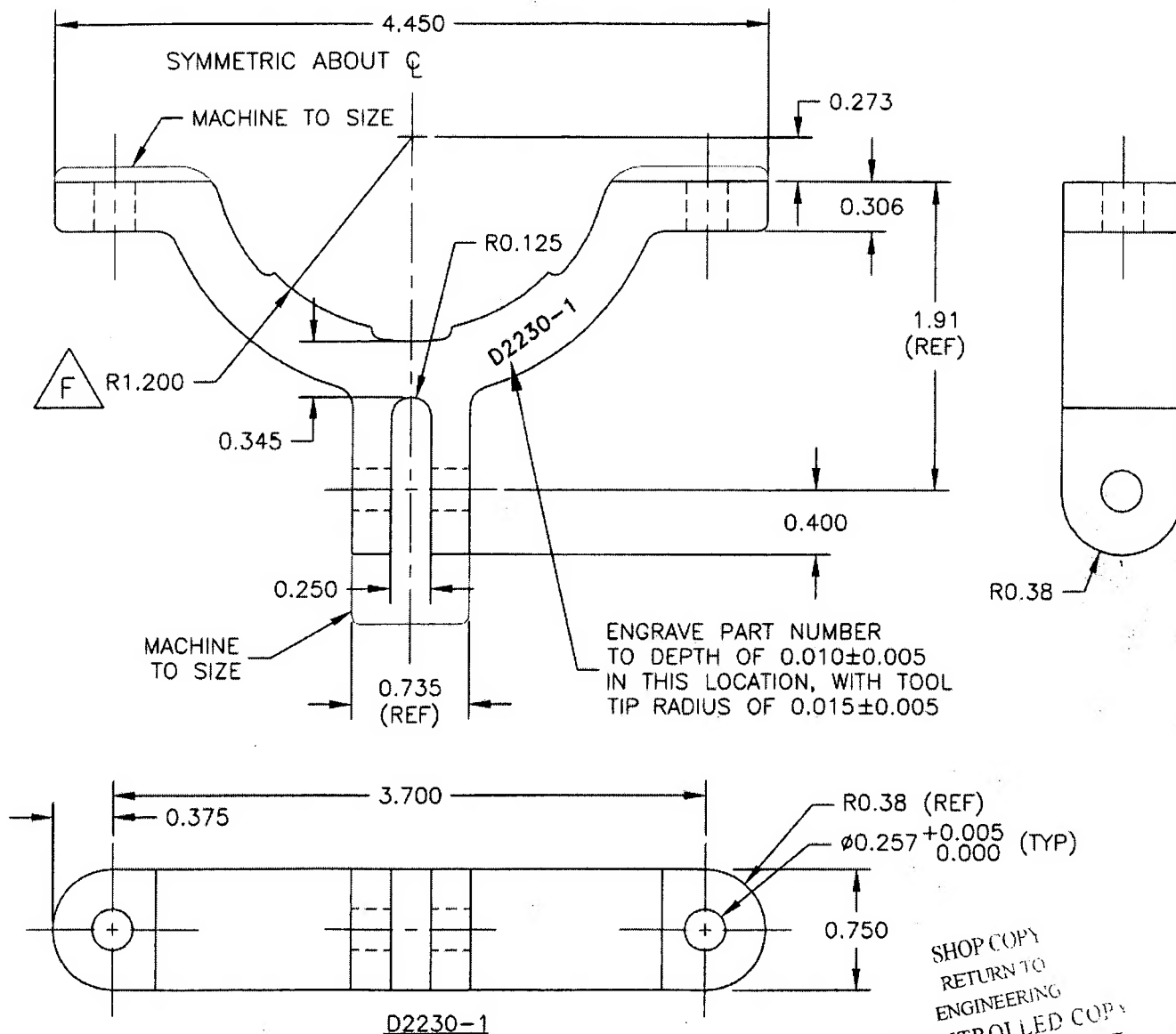
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN		
D	95.01.04	RE-DESIGN		
E	95.01.04	RE-DESIGN		
F	99.12.13	REDESIGN; R1.200 WAS R1.100		

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

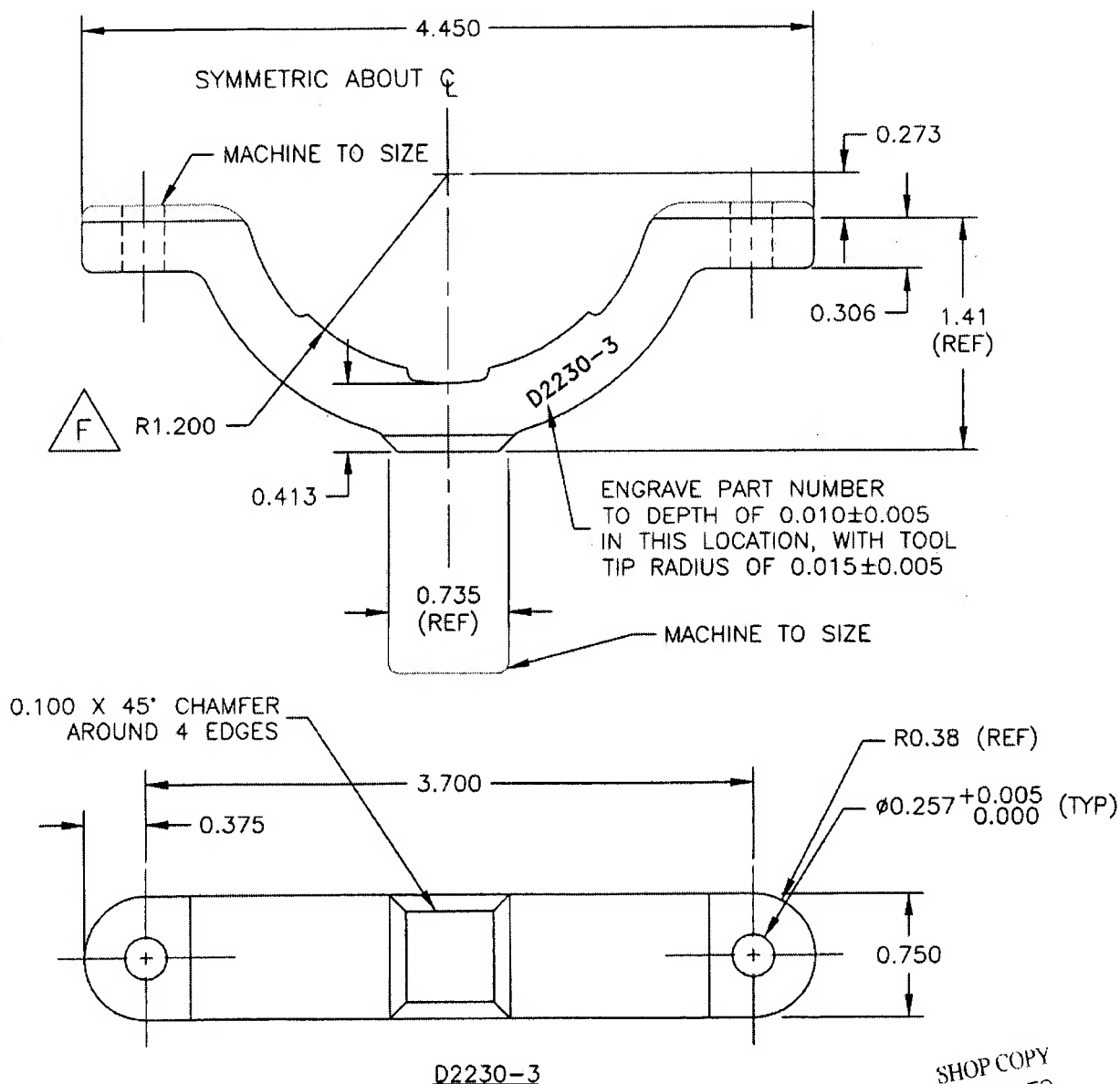
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
29806



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 29806

**CERTIFICATE OF CONFORMITY**

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITYPART NUMBERPART NAMEP.O. NUMBER

185

D2230-3 ✓

Lug B29806 ✓

2820 ✓

MATERIAL: supplied by DART D2423 B23779 ✓

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Denise Robinson

Vankleek Hill, January 29, 2007